



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2574**Job Sheet 211489****Part No:** D2574**Job Qty:** 8 pcs**Part Name:** Saddle, Aft, In**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 7/17/20**Job Tracking No:****Due Date:** 8/14/20**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV F IPP Rev: I As Per RevE 06-01-27 JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	8 pcs	8/13/20	0.00	0.00		HAAS - 1	52	20/08/26
							HAAS - 2	9-89	
							HAAS - 3		
							HAAS - 4		
100	HAAS 4 Axis - B4B	8 pcs	8/13/20	1.00	12.90		HAAS - 1 - B4B		DIP 20-09-01
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
110	Conventional Mill - 1 - B4B	8 pcs	8/13/20	0.00	1.00		Conventional Mill - 1 - B4B		DIP 20-09-01
							Conventional Mill - 2 - B4B		
120	QC 2	8 pcs	8/13/20	0.00	0.00		QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		



Dart Aerospace Ltd.
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CANADA
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Container No: S296130**Part:** D2574**Job No:** 211489**Serial No/Batch:** S296130**Revision:** Rev.F**Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 08/26/20

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				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	DSP 20-09-01
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
130 QC 8	8 pcs	8/13/20	0.00 0.00	QC 8 - 12	
				QC 8 - 14	20/09/09
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
140 Handfinish - 1-1 Chemical-B4B	8 pcs	8/13/20	0.00 1.00	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 -	

				B4B		
				Handfinish - 1 - 12 - B4B		
				Handfinish - 1 - 13 - B4B		
				Handfinish - 1 - 14 - B4B		
				Handfinish - 1 - 15 - B4B		
				Handfinish - 1 - 16 - B4B		
				Handfinish - 1 - 17 - B4B		
				Handfinish - 1 - 18 - B4B		
				Handfinish - 1 - 19 - B4B		
				Handfinish - 1 - 20 - B4B		
				Handfinish - 1 - 21 - B4B		
				Handfinish - 1 - 22 - B4B		
150	Powdercoat - 1 White Gl(A)- B4B	8 pcs	8/14/20	0.00	0.26	Powdercoat - 1 - B4B
						Powdercoat - 2 - B4B
						Powdercoat - 3 - B4B
						Powdercoat - 4 - B4B
						Powdercoat - 5 - B4B
						Powdercoat - 6 - B4B
						Powdercoat - 7 - B4B
						Powdercoat - 8 - B4B
						Powdercoat - 9 - B4B
						Powdercoat - 10 - B4B
160	QC 3	8 pcs	8/14/20	0.00	0.00	QC 3 - 10
						QC 3 - 13
						QC 3 - 15
						QC 3 - 17
						QC 3 - 18
						QC 3 - 2
						QC 3 - 28
						QC 3 - 3
						QC 3 - 30
						QC 3 - 34
						QC 3 - 36
						QC 3 - 41
						QC 3 - 51
						QC 3 - 58
						QC 3 - 59
						QC 3 - 68
						QC 3 - 9
						QC 3 - 40
						QC 3 - 19
						QC 3 - 43
						QC 3 - 24
						QC 3 - 61
						QC 3 - 81
						QC 3 - 82
						QC 3 - 87
170	Packaging 3-1 - Stock - B4B	8 pcs	8/14/20	0.00	0.00	Packaging 3 - 1 - B4B
						Packaging 3 - 2 - B4B
						Packaging 3 - 3 - B4B

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				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	DAS
				Packaging 3 - 8 - B4B	28
				Packaging 3 - 9 - B4B	9-89
				Packaging 3 - 10 - B4B	SEP 18 2020
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180 QC 21 - SA	8 pcs	8/14/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	28
				QC 21 - SA - 9	9-89
				QC 21 - SA - 77	SEP 18 2020

Part Op 100 - (HAAS CNC vertical machine #1) Program Batch No. 5296130 1-Machine Step No 1 per Folio FA051 and inspect
 Descriptions: per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

110 - (Manufacture as per dwg) Machine keyway as per dwg D2573 & D2574

120 - (QC2- Inspect parts off machine FA/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ FINISH TIME: _____

160 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	8 pcs (1 ea)	90-Machining - Issue SN	5279912 X 8

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Machining - Issue SN	D6101-005	8	12	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
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1	Saddle, Aft Inboard	0.438Inches	+ 0.005 - 0.000	0.443 0.438
2	Saddle, Aft Inboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745
3	Saddle, Aft Inboard	3.495Inches	+ 0.010 - 0.000	3.505 3.495
4	Saddle, Aft Inboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745
5	Saddle, Aft Inboard	7.990Inches	+ 0.020 - 0.000	8.010 7.990
6	Saddle, Aft Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
7	Saddle, Aft Inboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Aft Inboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Aft Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Aft Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Aft Inboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Aft Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Aft Inboard	1.365Inches	+ 0.010 - 0.000	1.375 1.365
14	Saddle, Aft Inboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Aft Inboard	4.119Inches	+ 0.010 - 0.000	4.129 4.119
16	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Aft Inboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Aft Inboard	3.210Inches	+ 0.040 - 0.000	3.250 3.210
22	Saddle, Aft Inboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Aft Inboard	0.307Inches	+ 0.005 - 0.000	0.312 0.307
25	Saddle, Aft Inboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Aft Inboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Aft Inboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Aft Inboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Aft Inboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Aft Inboard	1.500Inches	+ 0.020 - 0.000	1.520 1.500
32	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Aft Inboard	0.240Inches	+ 0.040	0.280

7/17/2020

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

			- 0.000	0.240
34	Saddle, Aft Inboard	0.240Inches	+ 0.020	0.260
			- 0.000	0.240
35	Saddle, Aft Inboard	2.000Inches	+ 0.020	2.020
			- 0.000	2.000
36	Saddle, Aft Inboard	0.023Inches	+ 0.020	0.043
			- 0.000	0.023

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DART AEROSPACE LTD	Work Order: 211489
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		0.500	0.497	0.498	0.499		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.375	0.375	0.376	0.376		
I	0.490	0.510		0.501	0.500	0.501	0.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.569	0.568	0.569	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.130	0.130	0.130	0.130		
Q	0.115	0.135		0.126	0.124	0.124	0.124		
R	0.240	0.260		0.255	0.255	0.255	0.255		
S	0.115	0.135		0.131	0.133	0.133	0.132		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.244	0.245	0.246	0.246		
W	0.115	0.135		0.135	0.130	0.130	0.130		
X	0.307	0.312		0.310	0.310	0.309	0.305		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.369	0.364	0.364	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.622	0.622	0.622	0.622		
AC	0.053	0.073		0.060	0.055	0.055	0.055		
AD	0.240	0.260		0.254	0.254	0.255	0.255		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.275	0.270	0.270	0.270		
AH	0.240	0.260		0.253	0.250	0.250	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

Measured by: 52	Audited by: [Signature]
Date: 02/08/26	Date: 20/09/09

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 211489
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		0.497	0.496	0.496	0.497		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.376	0.376	0.376	0.376		
I	0.490	0.510		0.500	0.500	0.502	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	0.570	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.130	0.130	0.130	0.130		
Q	0.115	0.135		0.123	0.123	0.124	0.124		
R	0.240	0.260		0.255	0.2545	0.255	0.255		
S	0.115	0.135		0.132	0.132	0.133	0.1325		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.244	0.244	0.245	0.243		
W	0.115	0.135		0.129	0.129	0.129	0.129		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.362	0.361	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.622	0.622	0.622	0.622		
AC	0.053	0.073		0.055	0.055	0.055	0.055		
AD	0.240	0.260		0.254	0.254	0.255	0.254		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.270	0.270	0.270	0.270		
AH	0.240	0.260		0.250	0.250	0.250	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: DIP
Date: 20-08-27

Audited by: Jm
Date: 20/09/09

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					